

Work Order ID 74867

October 13, 2011 10:35:25 AM

74867

Page 1

Item ID: D3537-1

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Wearpad

Stop

NS2

Start Date: 10/13/11 Start Qty: 60.00

60

Cust Item ID:

Required Date: 10/27/11 Req'd Qty: 60.00

60

Customer:

Reference:

Approvals:

Process Plan:

W

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D3537	Rev C	<i>W/K</i>	<i>OK QP 11.11.15</i>						

100 *100* FLOW WATER JET 0.00

Waterjet

Memo :0.00

B11-11-14

FLOW CNC Waterjet

1-Cut as per Dwg D3537Dwg Rev: *C* Prog Rev: *C* 2-Deburr
if necessary

(2)

110 QC2- Inspect parts off machine FAI/FAIB 0.00

110 QC

Memo :0.00

B11-11-14

Quality Control

120 QC8- Inspect parts - second check 0.00

120 QC

Memo :0.00

11.11.15 (2)

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: NC Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 74867

74867

October 13, 2011 10:35:25 AM

Page 3

Item ID: D3537-1

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Wearpad

Stop

NS2

Start Date: 10/13/11 Start Qty: 60.00

60

Cust Item ID:

Required Date: 10/27/11 Req'd Qty: 60.00

60

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00

✓ 11-29 (12)

160

QC

Quality Control

170

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

72x8M-p 11/11/30

170

Powdercoat

Powder Coating

Memo

10:45 0.00

START TIME:

OVEN TEMPERATURE:

320°F FINISH TIME:

11:15

180

QC3- Inspect Part Finish

0.00

*72 d 11/11/30
counted*

180

QC

Quality Control

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 74867

October 13, 2011 10:35:25 AM

74867

Page 4

Item ID: D3537-1

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Wearpad

Stop

NS2

Start Date: 10/13/11 **Start Qty:** 60.00

60

Cust Item ID:

Required Date: 10/27/11 **Req'd Qty:** 60.00

60

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

**Sequence ID/
Work Center ID**

**Operation
Description**

190

Identify as per dwg & Stock Location:

FPQ

**Set Up/
Run Hours**

0.00

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

**Reject
Qty**

**Reject
Number**

**Insp.
Stamp**

190

Packaging

Packaging

Memo

0.00

72X0/M/11/30

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Quality Control

Memo

0.00

11/12/11 DS

11/11/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

October 13, 2011 10:35:30 AM

Page 1

Work Order ID: 74867

74867

Parent Item: D3537-1

D3537-1

Parent Item Name: Wearpad

Start Date: 10/13/11

Required Date: 10/27/11

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	30.2000	0.106	6.694737	7.7		

M304S16GA

304/316 Sheet .063

Location	Loc Qty	Loc Code
MAT020	30.2	
118217	8	
118964	22.2	

119346

(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	74867
Description: Wearpad	Part Number:	D3537-1
Inspection Dwg: D3537	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

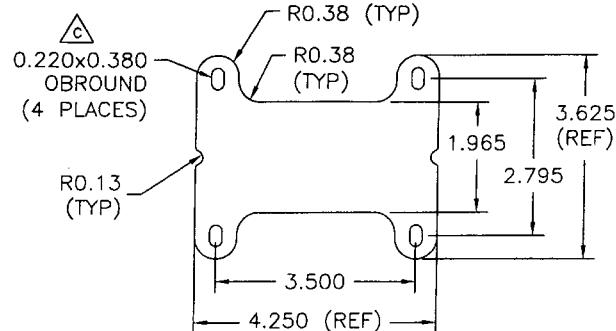
X First Article Prototype

Measured by:	<u>B</u>	Audited by:	<u>M. M.</u>	Prototype Approval:	N/A
Date:	(1-11-14)	Date:	(1-11-15)	Date:	N/A

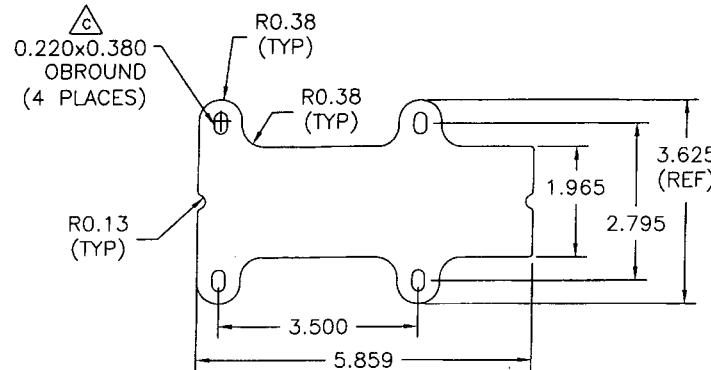
Rev	Date	Change	Revised by	Approved
A	07.03.21	New Issue	KJ/JLM	
B	07.04.27	Dimensions revised per Dwg Rev. B	KJ/JLM	
C	07.05.28	Dimensions revised per Dwg Rev. C	KJ/JLM	<i>[Signature]</i>

74867

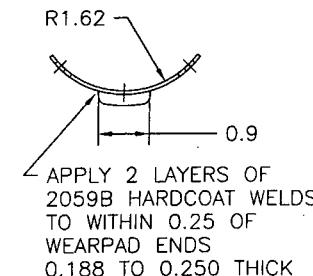
D3537-1F FLAT PATTERN



D3537-3F FLAT PATTERN



SECTION A-A

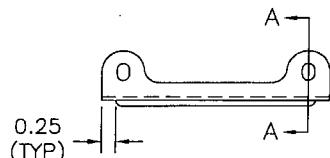


UNDER REVIEW

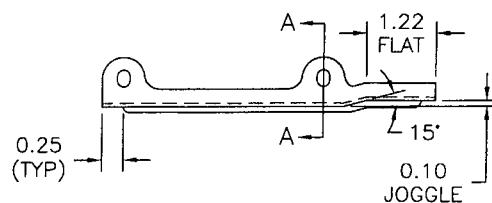
UNDER REVIEW 10/10/14 *Finnish*

THESE
RELEASED
03.05.08 AM

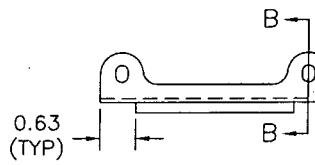
D3537-1 LONGITUDINAL BEND
(MADE FROM D3537-1F)



D3537-3 LONGITUDINAL BEND
(MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND
(MADE FROM D3537-1F)



D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
 - 2) BREAK ALL SHARP CORNERS 0.063 MAX
 - 3) WELD PER QSI 004
 - 4) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
 - 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 6) ALL DIMENSIONS ARE IN INCHES

COPYRIGHT © 2008 BY DART AEROSPACE USA, INC.
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL
AND IS SUPPLIED ON THE EXPRESS CONDITION
THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE USA, INC.

C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN		
B	07.03.20	ADD AMS 5513 AND AMS 5524		
A	06.11.06	NEW ISSUE		
DESIGN <i>CB</i>	DRAWN BY <i>PB</i>	DART	DART AEROSPACE USA, INC. PORT HEDLOCK, WA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3537	REV. C	SHEET 1 OF 1
DATE 07.04.13	TITLE WEARPAD	SCALE 1:2		